

Work Order ID 86495

Friday, June 29, 2012 3:40:25 PM

86495

Page 1

Item ID: D350-607-043A Accept ***N900040100*** Setup Start ***NS1***
 Revision ID:
 Item Name: Heli-Utility-Basket (Automatic Lid Opener) Stop ***NS2***
 Start Date: 6/29/2012 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 7/20/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: MF Date: 12-07-04 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
IIN-D350-607-1	A

100		0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Document Control	Photocopy bluefile & type labels per PPPD350-607-043A CHG001								

DAS
16
9-03
12/7/20

110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									

[Handwritten signature]
12/7/20

120	Small Fab	0.00							
120									
Small Fab	Memo	0.00							
Small Fab	Assemble as per Dwg D350-607								
	Seal Support Gusset with Sikaflex -291								
	Batch: <u>12/130</u>								
	Exp Date: <u>12-03</u>								

1 0 12/7-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 86495

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Page 2

Item ID: D350-607-043A

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Stop ***NS2***Start Date: 6/29/2012 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 7/20/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

Memo

0.00

Quality Control

140

Pick Kit

0.00

140

Packaging

Memo

0.00

Packaging

150

QC4- 100% Inspect kits for completeness

0.00

150

QC

Memo

0.00

Quality Control

DAS
16
8-3 12/1/20DAS
16
8-3 17/6/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 86495***86495***

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N900040100Setup Start ***NS1***

Revision ID:

Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Stop ***NS2***Start Date: 6/29/2012 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 7/20/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: Date: Tooling:

Date:

Run Start ***NR1***

QC: Date: SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

160

0.00

160

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-607-043A

Location: *SUMP**P 07/27/20 @*

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

*MLC 12/07/20**UMF 12-07-20*

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Picklist Print

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Page 1

Work Order ID: 86495

Parent Item: D350-607-043A

Parent Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 6/29/2012

Required Date: 7/20/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevB: as per dwg revC DD 10.01.18 verified by:EC
10.04.19 verified by:EC
IPP Rev:D 10.10.18 remove D350-607-143 and added individual parts of D350-607-143 in DD
verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3953-7 Spring Spacer		Manufactured	No				Each	47.0000		1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST075		47							
				82940		17							
				85789		30							
AN310-4 NUT		Purchased	No			110	Each	111.0000	2	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST344		111							
				121349		11							
				121827		100							
AN3C11A BOLT		Purchased	No			110	Each	40.0000	2	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST351		40							
				119798		40							
AN3C15A Bolt		Purchased	No			110	Each	37.0000	2	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST352		37							
				119973		37							
D2728-3 Dart Logo label		Manufactured	No			110	Each	0.0000	2	2			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Work Order ID: 86495

Parent Item: D350-607-043A

Parent Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 6/29/2012

Required Date: 7/20/2012

Start Qty: 1.00

Required Qty: 1.00

D3953-11
Gas Spring Spacer

Manufactured No

110 Each 5.0000

1

1

Location

Loc Qty

Loc Code

ST075

5

79338

5

79338

D3953-15
Gas Spring Bracket

Manufactured No

110 Each 19.0000

1

1

Location

Loc Qty

Loc Code

ST075

19

79337

19

79337

D3953-17
Gas Spring Spacer

Manufactured No

110 Each 37.0000

1

1

Location

Loc Qty

Loc Code

ST075

37

82937

13

85787

24

80787

D3953-3
Gas Spring Stud, Lid

Manufactured No

110 Each 37.0000

1

1

Location

Loc Qty

Loc Code

ST075

37

82939

7

85788

30

85788

D3953-5
Gas Spring Stud, Base

Manufactured No

110 Each 2.0000

1

1

Location

Loc Qty

Loc Code

ST075

2

77506

2

77506

D3953-9
Gas Spring Washer

Manufactured No

110 Each 27.0000

2

2

Location

Loc Qty

Loc Code

ST075

27

82941

27

82941

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Page 2

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 86495

Parent Item: D350-607-043A

Parent Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 6/29/2012

Required Date: 7/20/2012

Start Qty: 1.00

Required Qty: 1.00

D3969-1 Manufactured No
Spring (Basket Lid)

110 Each 25.0000

1

1

Location

Loc Qty

Loc Code

ST272

25

73523

5

84424

20

73523

MS21043-3 Purchased No
Nut

110 Each 1,202.0000

4

4

Location

Loc Qty

Loc Code

FG

72

103691

72

ST301

1130

118077

2

118614

12

118686

30

119758

20

121255

163

121708

903

11/21/2012

MS24665-2-12 Purchased No
COTTER PIN

110 Each 130.0000

2

2

Location

Loc Qty

Loc Code

ST309

130

118078

130

118078

NAS1149C0332R Purchased No
Washer

110 Each 9,466.0000

4

4

Location

Loc Qty

Loc Code

297

9400

122063

9400

ST297

66

121509

66

11/22/2012

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Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 86495

Parent Item: D350-607-043A

Parent Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 6/29/2012

Required Date: 7/20/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0432R

Purchased No

Washer

110 Each 3,606.0000

2

2

Location

Loc Qty

Loc Code

ST297

1102

117291

102

119124

1000

ST298

2504

121255

2504

D350-607-241 210001

Manufactured No

Basket Clamp Assembly

140 Each 4.0000

1

1

Location

Loc Qty

Loc Code

FG022

1

82555

1

PKG

1

82554

1

PKG12

-5

PKG13

7

85949

2

D2022-101

Manufactured No

Spacer

110 Each 44.0000

5

5

Location

Loc Qty

Loc Code

ST504

44

73307

1

79465

43

D2221

Manufactured No

350 Basket Base

110 Each 0.0000

1

1

D2258-200

Manufactured No

Placard 200lb

110 Each 25.0000

1

1

Location

Loc Qty

Loc Code

ST505

25

81888

15

84436

10

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Page 4

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Work Order ID: 86495

Parent Item: D350-607-043A

Parent Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 6/29/2012

Required Date: 7/20/2012

Start Qty: 1.00

Required Qty: 1.00

D2530 Manufactured No
Handle Weldment

110 Each 9.0000

1

1

86651

h

Location

Loc Qty

Loc Code

ST506

9

82895

1

83423

1

85779

7

D2535 Manufactured No
Spring

110 Each 56.0000

2

2

h

Location

Loc Qty

Loc Code

ST504

56

83545

56

2

2

83545

h

D2537 Manufactured No
Bushing

110 Each 24.0000

2

2

h

Location

Loc Qty

Loc Code

ST504

24

82896

24

82896

D2931 Manufactured No
Bumper

110 Each 400.0000

2

2

h

Location

Loc Qty

Loc Code

ST504

400

46064

400

46064

D2989-041 Manufactured No
Basket Lid Assembly

110 Each 0.0000

1

1

PR 12-7-20

D2989-043 Manufactured No
Basket Lid Assembly

110 Each 0.0000

1

1

PR 12-7-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

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Work Order ID: 86495

Parent Item: D350-607-043A

Parent Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 6/29/2012

Required Date: 7/20/2012

Start Qty: 1.00

Required Qty: 1.00

AN3-16A Purchased No

110 Each 105.0000 2 2

Bolt

Location

Loc Qty

Loc Code

ST352 105
117441 47
118628 1
120986 7
121708 50

AN4-13A Purchased No

110 Each 1,160.0000 2 2

Bolt

Location

Loc Qty

Loc Code

ST357 1160
120187 19
120422 2
120770 12
121652 929
122063 198

AN4-22A Purchased No

110 Each 167.0000 5 5

Bolt

Location

Loc Qty

Loc Code

ST359 167
116419 49
118628 68
120930 50

AN5-17A Purchased No

110 Each 148.0000 4 4

Bolt

Location

Loc Qty

Loc Code

338 4
121181 4
ST338 144
117872 34
121541 10
122151 100

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Work Order ID: 86495

Parent Item: D350-607-043A

Parent Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 6/29/2012

Required Date: 7/20/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1515H4

Purchased

No

110

Each

134.0000

2

2

Washer

Location

Loc Qty

Loc Code

ST277

134

116169

2

117735

3

118078

20

118612

9

120770

50

121649

50

118078

MS21042L3

Purchased

No

110

Each

3,423.0000

2

2

Nut

Location

Loc Qty

Loc Code

ST300

1423

117885

32

119017

777

119075

138

121444

476

ST317

2000

122141

2000

1121444

MS21042L4

Purchased

No

110

Each

1,782.0000

7

7

Nut

Location

Loc Qty

Loc Code

ST300

1782

119075

116

121011

193

121444

1173

121652

300

1121444

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 86495

Parent Item: D350-607-043A

Parent Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 6/29/2012

Required Date: 7/20/2012

Start Qty: 1.00

Required Qty: 1.00

MS21042L5

Purchased

No

110

Each

1,232.0000

4

4

Nut

Location

Loc Qty

Loc Code

300

500

121652

500

ST300

732

108827

4

116105

5

116548

43

117611

2

119109

666

17651

4

2937

8

6/19/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

AN3C15A BOLT
NAS1149C0332R WASHER
MS21043-3 NUT
2 PL

D3953-17
GAS SPRING SPACER

D3953-15
GAS SPRING BRACKET
REF

D3953-7
GAS SPRING SPACER

D3953-9
GAS SPRING WASHER

D3953-3 GAS SPRING STUD
AN310-4 CASTELLATED NUT
MS24665-212 COTTER PIN
NAS1149C0432R WASHER

VIEW G-G

AN3C11A BOLT
NAS1149C0332R WASHER
MS21043-3 NUT
2 PL

D3953-5
GAS SPRING STUD
REF

D3953-11
GAS SPRING SPACER

D3953-9
GAS SPRING WASHER

D3969-1
GAS SPRING
REF

AN310-4 CASTELLATED NUT
MS24665-212 COTTER PIN
NAS1149C0432R WASHER

VIEW H-H

G G

D3953-15
GAS SPRING BRACKET
REF

TRANSFER MARK AND
DRILL Ø0.194 THRU

TRIM MESH LOCALLY
AS REQUIRED

D3969-1
GAS SPRING
REF

DETAIL C

H H

D3953-5
GAS SPRING STUD
REF

TRIM MESH LOCALLY
AS REQUIRED

TRANSFER MARK AND
DRILL Ø0.194 THRU

DETAIL D

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 09.11.11
CERT. NO.: SH94-14
ISSUE NO.: 4

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	N/A	DSI 9473	SHEET 8 OF 8
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	AUTOMATIC LID OPENER INSTL	NTS
DATE	09.11.11	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

DART SERVICE INSTRUCTION

TO AMEND DRAWING D350-607 REV. F OR SUBSEQUENT APPROVED REVISION

REF CANADIAN STC: SH94-14

FAA STC: SR00213NY

EASA STC: EASA.IM.R.S.01405

THE PURPOSE OF THIS DART SERVICE INSTRUCTION (DSI), IS TO PROVIDE OPERATORS OF AS350 / 355 ROTORCRAFT EQUIPPED WITH DART D350-607-041 HELI UTILITY BASKETS WITH AN UPGRADE KIT TO REPLACE THE EXISTING LID PROP ARM WITH 2 GAS SPRINGS.

FOR OPERATORS EQUIPPED WITH D350-607-043/-045/-047 HELI UTILITY BASKETS THIS DSI WILL PROVIDE AN UPGRADE KIT TO REPLACE THE EXISTING LID PROP ARM WITH 1 GAS SPRING.

ITEM No.	QTY -141	QTY -143	QTY -145	PART NUMBER	DESCRIPTION
1	X			D350-607-141	AUTOMATIC LID OPENER INSTL (FOR USE ON -041 BASKET*)
2		X		D350-607-143	AUTOMATIC LID OPENER INSTL (FOR USE ON -043/-047 BASKET*)
3			X	D350-607-145	AUTOMATIC LID OPENER INSTL (FOR USE ON -045 BASKET*)
4	2		1	D3953-1	GAS SPRING BRACKET
5	2	1	1	D3953-3	GAS SPRING STUD (LID)
6	2	1	1	D3953-5	GAS SPRING STUD (BASE)
7	2	1	1	D3953-7	GAS SPRING SPACER
8	4	2	2	D3953-9	GAS SPRING WASHER
9	2	1	1	D3953-11	GAS SPRING SPACER
10	2		1	D3953-13	GAS SPRING SPACER
11		1		D3953-15	GAS SPRING BRACKET
12		1		D3953-17	GAS SPRING SPACER
13	2	1	1	D3969-1	GAS SPRING
14	4	2	2	AN3C11A	BOLT
15		2		AN3C15A	BOLT
18	4		2	AN3C16A	BOLT
19	4	2	2	AN310-4	CASTELLATED NUT
20	8	4	4	MS21043-3	NUT
21	4	2	2	MS24665-212	COTTER PIN
22	8	4	4	NAS1149C0332R	WASHER (OR AN960C10L)
23	4	2	2	NAS1149C0432R	WASHER (OR AN960C416L)

***NOTE:** FOR CUSTOMERS WISHING TO ORDER NEW BASKETS WITH THE LID OPENER PRE-INSTALLED USE THE FOLLOWING NUMBERS:

D350-607-041 BASKET WITH AUTOMATIC LID OPENER INSTALLED = D350-607-041A
D350-607-043 BASKET WITH AUTOMATIC LID OPENER INSTALLED = D350-607-043A
D350-607-045 BASKET WITH AUTOMATIC LID OPENER INSTALLED = D350-607-045A
D350-607-047 BASKET WITH AUTOMATIC LID OPENER INSTALLED = D350-607-047A

wp86495

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C	SHEET 1 PL, -143 INSTL, ITEM 6 QTY WAS 2, ITEM 7 WAS 0.	AJS	09.11.11
B	SHT 1 P/L ITEM 22 WAS NAS1149C0332 ITEM 23 WAS NAS1149C0432H. ALL OTHER SHEETS UPDATED ACCORDINGLY. (REASON: DRAFTING ERROR) INSTALLATIONS RENAMED.	AJS	09.11.06
A	NEW ISSUE	AJS	09.09.15
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. REV. C DSI 9473 SHEET 1 OF 8 TITLE SCALE AUTOMATIC LID OPENER INSTL NTS <small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
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DE APPR.	<i>[Signature]</i>		
DATE	09.11.11		

FOR D350-607-041 BASKETS, REPLACE THE EXISTING D2332-041 PROP ARM ASSEMBLY AS FOLLOWS:

D350-607-141 AUTOMATIC LID OPENER INSTALLATION

NOTE: ONCE THIS MODIFICATION IS COMPLETE YOU WILL NOT BE ABLE TO RE-INSTALL THE D2332-041 PROP ARM.

- 1) REMOVE THE D2332-041 PROP ARM.
- 2) GRIND FLUSH THE D2327-3 SPACER BUSHING ON BOTH ENDS OF THE BASKET AS SHOWN IN FIGURE 1 (IT IS PERMISSIBLE TO GRIND ALL 4 SPACERS FLUSH). TOUCH UP PAINT PER ICA-D350-607 REV. 0 SECTION 5.1 ITEM 4.
- 3) LOCATE THE D3953-1 GAS SPRING BRACKET AS SHOWN IN FIGURE 1. TRIM STEEL MESH LOCALLY AS REQUIRED. TOUCH UP PAINT PER ICA-D350-607 REV. 0 SECTION 5.1 ITEM 4. TRANSFER MARK AND DRILL 2X Ø0.194 HOLES THRU THE BASKET LID SQUARE TUBE STRUCTURE AS SHOWN IN DETAIL A. INSTALL THE D3953-1 GAS SPRING BRACKET & D3953-13 GAS SPRING SPACER USING 2X AN3C16A BOLT, 2X NAS1149C0332R WASHER & 2X MS21043-3 NUT AS SHOWN IN VIEW E-E.
- 4) LOCATE THE D3953-5 GAS SPRING STUD AS SHOWN IN FIGURE 1. TRIM STEEL MESH LOCALLY AS REQUIRED. TOUCH UP PAINT PER ICA-D350-607 REV. 0 SECTION 5.1 ITEM 4. TRANSFER MARK AND DRILL 2X Ø0.194 HOLES THRU THE BASKET BASE SQUARE TUBE STRUCTURE AS SHOWN IN DETAIL B. FASTEN D3953-5 IAW VIEW F-F USING 2X AN3C11A BOLT, 2X NAS1149C0332R WASHER & 2X MS21043-3 NUT.
- 5) INSTALL 1X D3953-11 GAS SPRING SPACER ONTO THE D3953-5 STUD AS SHOWN IN VIEW F-F. INSTALL THE LARGE END OF THE D3969-1 GAS SPRING SPRING ONTO THE D3953-5 GAS SPRING STUD AND FASTEN IN PLACE USING 1X D3953-9 GAS SPRING WASHER, 1X NAS1149C0432R WASHER, 1X AN310-4 CASTELATTED NUT & 1X MS24665-212 COTTER PIN AS SHOWN IN VIEW F-F. INSTALL COTTER PIN PER MS33540 OR AC43.13 CHAPTER 7-127.
- 6) INSERT THE D3953-3 GAS SPRING STUD INTO THE D3953-1 GAS SPRING BRACKET & INSERT THE D3953-7 GAS SPRING SPACER ONTO THE D3953-3 GAS SPRING AS SHOWN IN VIEW E-E. RAISE THE BASKET LID AND INSTALL THE ROD END OF THE D3969-1 GAS SPRING ONTO THE D3953-3 GAS SPRING STUD USING 1X D3953-9 GAS SPRING WASHER, 1X NAS1149C0432R WASHER, 1X AN310-4 CASTELATTED NUT & 1X MS24665-212 COTTER PIN AS SHOWN IN VIEW E-E. INSTALL COTTER PIN PER MS33540 OR AC43.13 CHAPTER 7-127.

NOTE: THE D3953-3 GAS SPRING STUD CAN BE HELD IN PLACE WITH A $\frac{9}{16}$ OPEN END SPANNER / WRENCH.

NOTE: WITH THE LID IN THE CLOSED POSITION THE GAS SPRING SHOULD NOT BE FULLY COMPRESSED.



- 7) REPEAT STEPS 2 THROUGH 6 AT THE OTHER END OF THE BASKET.
- 8) TEST THE INSTALLATION. IF INSTALLED PROPERLY THE GAS SPRINGS SHOULD ASSIST THE BASKET USER IN BOTH OPENING AND CLOSING THE BASKET LID.

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BRANCH
DAO # 01-O-01

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BY: 
D. SHEPHERD (DE # 02)

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FOR D350-607-043/-047 BASKETS REPLACE THE EXISTING D2332-041 PROP ARM ASSEMBLY AS FOLLOWS:

D350-607-143 AUTOMATIC LID OPENER INSTALLATION

NOTE: THIS KIT MAY BE INSTALLED AT EITHER END OF THE BASKET. HOWEVER, THE PROP ARM MUST BE REMOVED IN EITHER CASE AS IT WILL INTERFERE WITH THE FUNCTION OF THE GAS SPRING.




- 1) REMOVE THE D2332-041 PROP ARM.
- 2) GRIND FLUSH THE D2327-3 SPACER BUSHING ON THE END OF THE BASKET WHERE THE LID OPENER IS BE INSTALLED AS SHOWN IN FIGURE 2 (IT IS PERMISSIBLE TO GRIND ALL 4 SPACERS FLUSH). TOUCH UP PAINT PER ICA-D350-607 REV. 0 SECTION 5.1 ITEM 4.
- 3) LOCATE THE D3953-15 GAS SPRING BRACKET AS SHOWN IN FIGURE 2. TRIM STEEL MESH LOCALLY AS REQUIRED. TOUCH UP PAINT PER ICA-D350-607 REV. 0 SECTION 5.1 ITEM 4. TRANSFER MARK AND DRILL 2X Ø0.194 HOLES THRU THE BASKET LID SQUARE TUBE STRUCTURE AS SHOWN IN DETAIL C. INSTALL THE D3953-15 GAS SPRING BRACKET & D3953-17 GAS SPRING SPACER USING 2X AN3C15A BOLT, 2X NAS1149C0332R WASHER & 2X MS21043-3 NUT AS SHOWN IN VIEW G-G.
- 4) LOCATE THE D3953-5 GAS SPRING STUD AS SHOWN IN FIGURE 2. TRIM STEEL MESH LOCALLY AS REQUIRED. TOUCH UP PAINT PER ICA-D350-607 REV. 0 SECTION 5.1 ITEM 4. TRANSFER MARK AND DRILL 2X Ø0.194 HOLES THRU THE BASKET BASE SQUARE TUBE STRUCTURE AS SHOWN IN DETAIL D. INSTALL 2X AN3C11A BOLT, 2X NAS1149C0332R WASHER & 2X MS21043-3 NUT AS SHOWN IN VIEW H-H. INSTALL THE ROD END OF THE D3969-1 GAS SPRING ONTO THE D3953-3 GAS SPRING STUD USING 1X D3953-9 GAS SPRING WASHER, 1X NAS1149C0432R WASHER, 1X AN310-4 CASTELATTED NUT & 1X MS24665-212 COTTER PIN AS SHOWN IN VIEW H-H. INSTALL COTTER PIN PER MS33540 OR AC43.13 CHAPTER 7-127.
- 5) INSERT THE D3953-3 GAS SPRING STUD INTO THE D3953-15 GAS SPRING BRACKET & INSERT THE D3953-7 GAS SPRING SPACER ONTO THE D3953-3 GAS SPRING STUD AS SHOWN IN VIEW G-G. RAISE THE BASKET LID AND INSTALL THE D3969-1 GAS SPRING ONTO THE D3953-3 GAS SPRING STUD AND FASTEN IN PLACE USING 1X D3953-9 GAS SPRING WASHER, 1X NAS1149C0432R WASHER, 1X AN310-4 CASTELATTED NUT & 1X MS24665-212 COTTER PIN AS SHOWN IN VIEW G-G. INSTALL COTTER PIN PER MS33540 OR AC43.13 CHAPTER 7-127.

NOTE: THE D3953-3 GAS SPRING STUD CAN BE HELD IN PLACE WITH A $\frac{9}{16}$ OPEN END SPANNER / WRENCH.

NOTE: WITH THE LID IN THE CLOSED POSITION THE GAS SPRING SHOULD NOT BE FULLY COMPRESSED.

- 6) TEST THE INSTALLATION. IF INSTALLED PROPERLY THE GAS SPRING SHOULD ASSIST THE BASKET USER IN BOTH OPENING AND CLOSING THE BASKET LID.

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FOR D350-607-045 BASKETS REPLACE THE EXISTING D2332-041 PROP ARM ASSEMBLY AS FOLLOWS:

D350-607-145 AUTOMATIC LID OPENER INSTALLATION

NOTE: THIS KIT MAY BE INSTALLED AT EITHER END OF THE BASKET. HOWEVER, THE PROP ARM MUST BE REMOVED IN EITHER CASE AS IT WILL INTERFERE WITH THE FUNCTION OF THE GAS SPRING.

- 1) REMOVE THE D2332-041 PROP ARM.
 - 2) GRIND FLUSH THE D2327-3 SPACER BUSHING ON THE END OF THE BASKET WHERE THE LID OPENER IS BE INSTALLED AS SHOWN IN FIGURE 1 (IT IS PERMISSIBLE TO GRIND ALL 4 SPACERS FLUSH). TOUCH UP PAINT PER ICA-D350-607 REV. 0 SECTION 5.1 ITEM 4.
 - 3) LOCATE THE D3953-1 GAS SPRING BRACKET AS SHOWN IN FIGURE 1. TRIM STEEL MESH LOCALLY AS REQUIRED. TOUCH UP PAINT PER ICA-D350-607 REV. 0 SECTION 5.1 ITEM 4. TRANSFER MARK AND DRILL 2X Ø0.194 HOLES THRU THE BASKET LID SQUARE TUBE STRUCTURE AS SHOWN IN DETAIL A. INSTALL THE D3953-1 GAS SPRING BRACKET & D3953-13 GAS SPRING SPACER USING 2X AN3C16A BOLT, 2X NAS1149C0332R WASHER & 2X MS21043-3 NUT AS SHOWN IN VIEW E-E.
 - 4) LOCATE THE D3953-5 GAS SPRING STUD AS SHOWN IN FIGURE 1. TRIM STEEL MESH LOCALLY AS REQUIRED. TOUCH UP PAINT PER ICA-D350-607 REV. 0 SECTION 5.1 ITEM 4. TRANSFER MARK AND DRILL 2X Ø0.194 HOLES THRU THE BASKET BASE SQUARE TUBE STRUCTURE AS SHOWN IN DETAIL B. FASTEN D3953-5 IAW VIEW F-F USING 2X AN3C11A BOLT, 2X NAS1149C0332R WASHER & 2X MS21043-3 NUT.
 - 5) INSTALL 1X D3953-11 GAS SPRING SPACER ONTO THE D3953-5 STUD AS SHOWN IN VIEW F-F. INSTALL THE LARGE END OF THE D3969-1 GAS SPRING SPRING ONTO THE D3953-5 GAS SPRING STUD AND FASTEN IN PLACE USING 1X D3953-9 GAS SPRING WASHER, 1X NAS1149C0432R WASHER, 1X AN310-4 CASTELATTED NUT & 1X MS24665-212 COTTER PIN AS SHOWN IN VIEW F-F. INSTALL COTTER PIN PER MS33540 OR AC43.13 CHAPTER 7-127.
 - 6) INSERT THE D3953-3 GAS SPRING STUD INTO THE D3953-1 GAS SPRING BRACKET & INSERT THE D3953-7 GAS SPRING SPACER ONTO THE D3953-3 GAS SPRING AS SHOWN IN VIEW E-E. RAISE THE BASKET LID AND INSTALL THE ROD END OF THE D3969-1 GAS SPRING ONTO THE D3953-3 GAS SPRING STUD USING 1X D3953-9 GAS SPRING WASHER, 1X NAS1149C0432R WASHER, 1X AN310-4 CASTELATTED NUT & 1X MS24665-212 COTTER PIN AS SHOWN IN VIEW E-E. INSTALL COTTER PIN PER MS33540 OR AC43.13 CHAPTER 7-127.
- NOTE:** THE D3953-3 GAS SPRING STUD CAN BE HELD IN PLACE WITH A $\frac{9}{16}$ OPEN END SPANNER / WRENCH.

NOTE: WITH THE LID IN THE CLOSED POSITION THE GAS SPRING SHOULD NOT BE FULLY COMPRESSED.



- 7) TEST THE INSTALLATION. IF INSTALLED PROPERLY THE GAS SPRING SHOULD ASSIST THE BASKET USER IN BOTH OPENING AND CLOSING THE BASKET LID.

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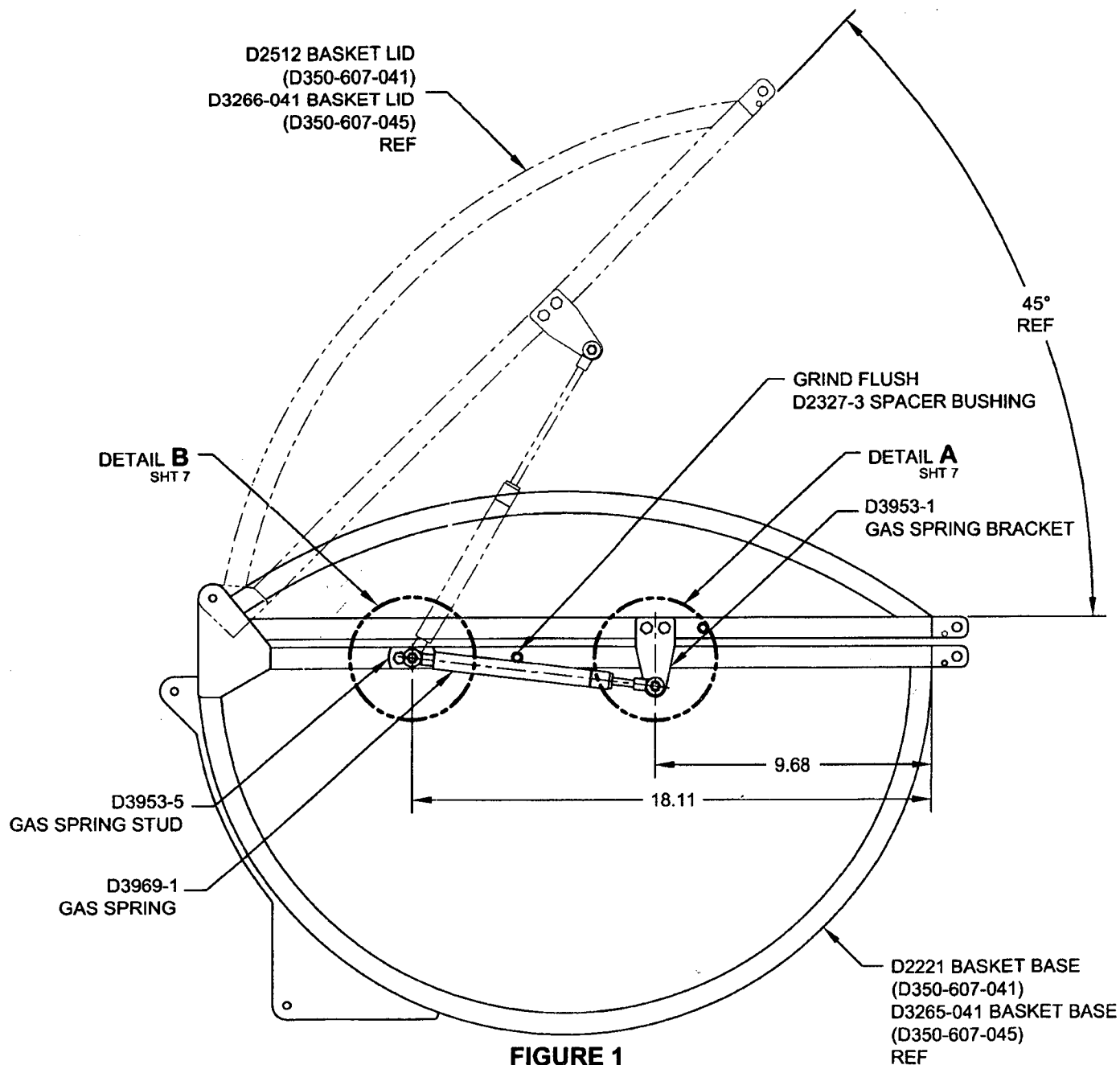


FIGURE 1

D350-607-141 AUTOMATIC LID OPENER INSTALLATION

(BOTH ENDS)

D350-607-145 AUTOMATIC LID OPENER INSTALLATION

(1 END ONLY)

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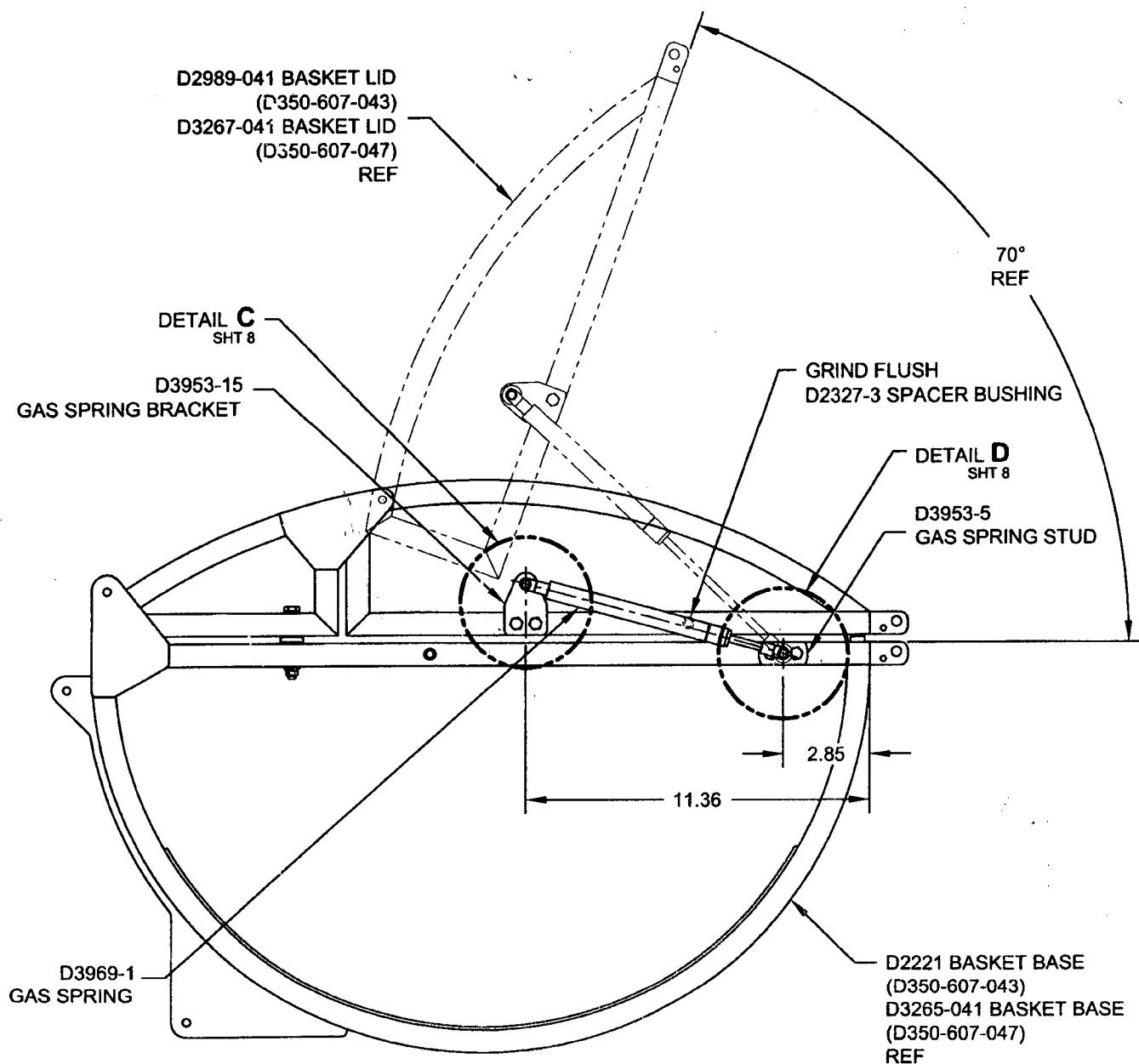





FIGURE 2
D350-607-143 AUTOMATIC LID OPENER INSTALLATION
 (1 END ONLY)

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AN3C11A BOLT
NAS1149C0332R WASHER
MS21043-3 NUT
2 PL

D3953-5
GAS SPRING STUD
REF
D3953-11
GAS SPRING SPACER
D3953-9
GAS SPRING WASHER
AN310-4 CASTELLATED NUT
MS24665-212 COTTER PIN
NAS1149C0432R WASHER

VIEW F-F

AN3C16A BOLT
NAS1149C0332R WASHER
MS21043-3 NUT
2 PL

D3969-1
GAS SPRING
REF

VIEW E-E

D3953-13
GAS SPRING SPACER
D3953-1
GAS SPRING BRACKET
REF
D3953-7
GAS SPRING SPACER
D3953-9
GAS SPRING WASHER
D3953-3 GAS SPRING STUD
AN310-4 CASTELLATED NUT
MS24665-212 COTTER PIN
NAS1149C0432R WASHER

D3953-5
GAS SPRING STUD
REF

TRIM MESH LOCALLY
AS REQUIRED

TRANSFER MARK AND
DRILL Ø0.194 THRU
2 PL

DETAIL B

TRIM MESH LOCALLY
AS REQUIRED

TRANSFER MARK AND
DRILL Ø0.194 THRU

D3953-1
GAS SPRING BRACKET
REF

DETAIL A

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